

Work Order ID 57551



Page 1

April 8, 2010 9:22:17 AM

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 4/08/10 Start Qty: 8.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

[Signature] 4/10/20 (8)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

[Signature] 10/04/21

(13)

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M105642

[Signature] 10/04/22

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:00 AM OVEN TEMPERATURE:

7:30 AM FINISH TIME:

X8 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57551

April 8, 2010 9:22:17 AM



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Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 4/08/10 Start Qty: 8.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							BR 10-4-22
140 	Small Fab	0.00							
Small Fab Small Fab	Memo Assemble as per Dwg D3296	0.00							4/30/04/22
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							8/10/04/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57551

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Item ID: D3296-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Assembly

Start Date: 4/08/10 Start Qty: 8.00

Required Date: 4/16/10 Req'd Qty: 8.00

Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

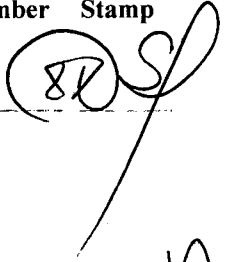

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Identify as per dwg & Stock Location <u>2/K</u> Memo	0.00 0.00							
170  QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.00							

10-4-22

10/04/23 MR
10-4-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 8, 2010 9:22:14 AM

Work Order ID: 57551



Parent Item: D3296-041



Parent Item Name: Door Assembly

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2462		Manufactured	No			140	f	640.0000	2.6664			
Seal												

ES 10/04/22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST404

640

48530

640

D2728-1

Manufactured No

140

Each

0.0000

0.0000



Dart Logo label

D3161-7

Manufactured No

100

Each

8.0000

8.0000



Hinge 14.0"

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST040

8

52029

8

2.6664

ES 10/04/19

ES 10/04/19

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 9:22:14 AM

Work Order ID: 57551



Parent Item: D3296-041



Parent Item Name: Door Assembly

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3161-9		Manufactured	No			100	Each	27.0000	8.0000			
Hinge 17.0"												

8/5/10/04/19

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST040	27	
52332	12	
53000	5	
53228	10	

3
5

D3296-1 Manufactured No



Door Panel

D3296-3



Door Panel

100 Each 0.0000 8.0000

B 57739



8/5/10/04/19

100 Each 4.0000 8.0000



8/5/10/04/19

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST186	4	
52271	4	
57740		

5
3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 57551



Parent Item: D3296-041



Parent Item Name: Door Assembly

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-4		Purchased	No			140	Each	3,110.000	200.0000			
Rivet, Universal Head												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ST319
112314
113368

3110
489
2621

ES 10/04/19

200

MS20470AD4-6		Purchased	No			100	Each	1,292.000	8.0000			
Rivet, Universal Head												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ST320
113644

1292
1292

ES 10/04/19

8

April 8, 2010 9:22:15 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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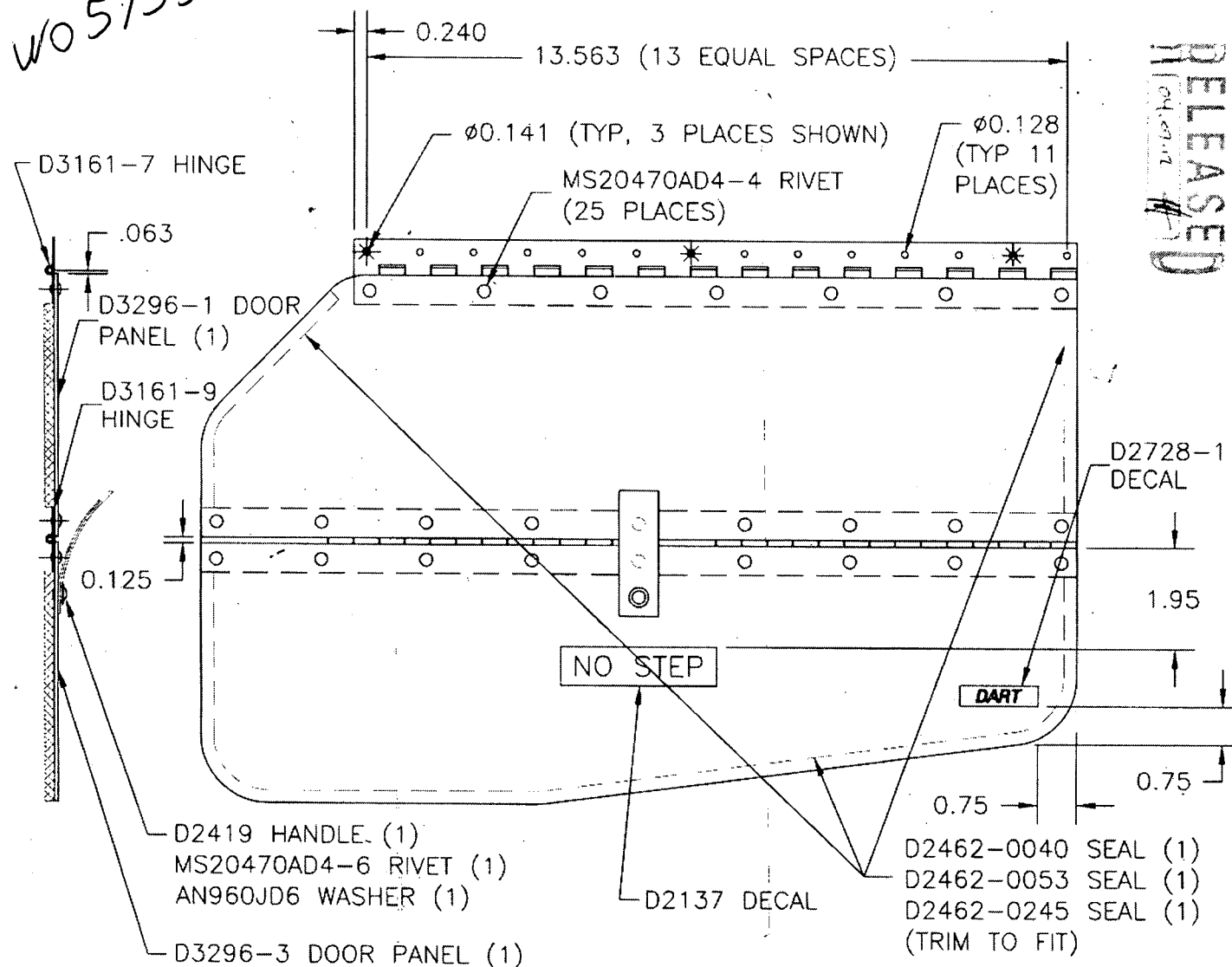
NOTE: Date & initial all entries



RELEASED
04.06.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		REV. A	
04.06.28		DOOR ASSEMBLY		1 OF 2	
A		NEW ISSUE		SCALE	
				1:3	

WO 57551



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



7 deadly wastes

- 1. Overproduction***
- 2. Rework***
- 3. Transportation***
- 4. Inappropriate / over Processing***
- 5. Unnecessary Inventory***
- 6. Delays / Waiting***
- 7. Unnecessary Motions***



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5S basics

- **Sort (Seiri) (整理):** Sorting. Refers to the practice of going through all the tools, materials, etc., in the work area and keeping only essential items. Everything else is stored or discarded. This leads to fewer hazards and less clutter to interfere with productive work.
- **Set in order (Seiton) (整頓):** Simplifying. Focuses on the need for an orderly workplace. "Orderly" in this sense means arranging the tools and equipment in an order that promotes work flow. Tools and equipment should be kept where they will be used, and the process should be ordered in a manner that eliminates extra motion.
- **Shine (Seisō) (清掃):** Sweeping, Systematic Cleaning, or Shining. Indicates the need to keep the workplace clean as well as neat. At the end of each shift, the work area is cleaned up and everything is restored to its place. The key point is that maintaining cleanliness should be part of the daily work - not an occasional activity initiated when things get too messy.